Polypropylene (PP) Resin Parts

Repair Materials and Tools

The following materials and tools are required to resin bumpers:

Adhesive and Filler (examples):
- Bumper primer (clear type)
- Bond quick mender
- High art mat black
- High art thinner
- High art hardener

Primer surfacer (examples).
- Dual-liquid type bumper primer surfacer (gray) Reference (Isam Paint)
- Pigment: (1kg) (35.3 oz)
- Hardener: (100g) (3.5 oz)
- Thinner: (900 mℓ) (30.4 fℓ. oz, 31.7 Imp. oz)

NOTE: Follow the manufacturer's recommendations

Tools:
- Putty knife
- Base (putty)
- Sandpaper
- Cutter
- Brush
- Masking tape
- Masking paper

1. Bumper Primer (Clear): Premixed type

The primer provides a good support for the filler and primer surfacer. It is applied to the surface of the bumper.

Drying time:

Natural	68°F (20°C) 20 minutes
Baked	140°F (60°C) 10 minutes

2. PUTTY BOND QUICK MENDER

After the PP primer has dried thoroughly, apply the PUTTY BOND QUICK MENDER.

- 1. Mix one part of the mender (A) and one part of the hardener (B) and stir thoroughly.

NOTE: Do not mix the mender and hardener in excess of 20g (0.7oz) at a time.

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Repair Materials and Tools (cont'd)

-2. Hardening starts immediately after mixing.
Practical hardness will be obtained within 60 minutes. The surface will be tacky within 5 minutes and nearly hardened after 15 minutes. It takes 12 hours for the surface to harden thoroughly 68°F (20°C)

-3. Sanding can be done after:

3 hours	68°F (20°C)-natural drying
30 minutes	140°F (60°C)-baked

3. Primer Surfacer

NOTE: Use a dual-liquid type bumper primer surfacer (gray).

- The primer surface is used to protect the PP resin surface and to fill cavities or flaws in the intermediate and top coats.
- Mix 10 parts of primer surfacer and 1 part of hardener. Add the specific thinner (30-60%) to the mixture of the hardener and primer to attain the proper viscosity for spraying.

4. Intermediate and Top Paint Coats (body color)

NOTE:
- The paints are the dual liquid type based on the color chart.
- Measure the pigment and hardener as described so they are in correct ratio.
- Use the acrylic urethane paint prepared according to the mixing chart as the intermediate coat.

Mixing Ratio:
Mix 5 parts of body color pigment to 1 part of additive.
Mix 4 parts of the mixture of the pigment and additive with 1 part of the hardener.

NOTE:
- Dilute the mixture with 40-50% of the specified thinner (Highart Thinner).
- Be sure to mix the correct amount of the additive.
- Use a spray gun to apply the paint. Do not use a brush.

⚠ WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

Drying time:

Natural	68°F(20°C)
Surface only	20 minutes
Almost hardened	4 hours
Thoroughly hardened	96 hours

NOTE: The HIGH ART MAT BLACK SURFACER is a dual liquid type. If mixed, it will harden in a matter of hours.